



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D5412-041
Job Sheet 191709



Part No: D5412-041

Job Qty: 20 pcs

Part Name: Crosstube Clamp Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/6/19

Job Tracking No:

Due Date: 4/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: TBD D5412 REV.B IPP Rev: A RQ 16.09.21 Verified by: DD IPP REV: B 17.10.16 AS PER DWG REV.b DD
VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	20 pcs	4/1/19	4/1/19	0.00	2.00	Bandsaw - 1		19-03-28
110	HAAS 4 Axis - B4B	20 pcs	4/1/19	4/1/19	0.00	39.22	HAAS - 1 - B4B		19-04-05
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	20 pcs	4/1/19	4/1/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		19-04-05
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		



Container No: S167693



Part: D5412-041

Job No: 191709

Serial No/Batch: S167693

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA
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Date: 03/28/19

Plex 3/6/19 1:31 PM Dart.lajeunesse.marie

130 QC 8	20 pcs	4/1/19	0.00 0.00	QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20 23	148 19/4/7
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
140 Handfinish - 1-1 Chemical-B4B	20 pcs	4/1/19	0.00 5.92	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/04/10
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	

					Handfinish - 1 - 22 - B4B	
150	Spray Paint - 2 - B4B	20 pcs	4/1/19	0.00 5.00	Spray Paint - 1 - B4B	APR 19-4-21
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
160	QC 14	20 pcs	4/1/19	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	DAS
					QC 14 - 40	APR 4 2019 40
165	Small Fab - 2 - B4B	20 pcs	4/1/19	0.00 4.20	Small Fab - 1 - B4B	58 9-89
					Small Fab - 2 - B4B	9-89 APR 7 5 2019
					Small Fab - 3 - B4B	DAS
					Small Fab - 4 - B4B	71
					Small Fab - 5 - B4B	19-6-19 9-89
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
168	QC 5	20 pcs	4/1/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS
					QC 5 - 9	JUN 1 9 2019 40
					QC 5 - 50	9-89
					QC 5 - 30	
170	Packaging 3-1 - Stock - B4B	20 pcs	4/1/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	

					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	Pc 51230A
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	20 pcs	4/1/19	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	5-85

Part Op 100 - Cut Blanks 4.80" long
 Descriptions: 110 - (HAAS CNC Vertical Machine), Machine as per Folio FB497 Folio Rev: _____ Dwg Rev: _____ 2-
 Deburr
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - (Spray Paint / NDT Room), ***MASK THREAD*** PRIME AS PER DWG QSI005 4.2.1.3.3
 BATCH: 5155827 PAINT AS PER DWG QSI005 4.2.2.4 BATCH: 5163577
 160 - QC14- Inspect Spray Paint
 165 - INSTALL HELICOIL AND BOLT AS PER DRAWING. ***INSTALL BOLT LOOSE AS PER NOTE 9***
 168 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

JUN 21 2019

Job BOM					Container
Part / Item	Component Name	Quantity	Operation		
M6061T6B1.250X4.500	6061-T6 Bar 1.25 X 4.50	8 ft (.4 ea)	100-Bandsaw - 1		5131147
MS20002C4	Washer	30 20 pcs (1 ea)	165-Small Fab - 2 - B4B		5159227
MS21209-F420	Heli-Coil	30 20 Ea (1 ea)	165-Small Fab - 2 - B4B		5155811
MS21250-04012	Bolt	30 20 Ea (1 ea)	165-Small Fab - 2 - B4B		515061
					5065258

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X4.500	8	24	0
165-Small Fab - 2 - B4B	MS20002C4	20	100	0
	MS21209-F420 MEZZ	20	82	0
	MS21250-04012	20	70	0

Part Specifications
Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					